



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4202-1**Job Sheet 186737****Part No:** D4202-1**Job Qty:** 150 ea**Part Name:** Spacer**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 11/20/18**Job Tracking No:****Due Date:** 12/14/18**Created By:** Jesse White**Type:** SOLD**Description:**

Note: DWG REV C IPP REV:A NEW ISSUE 10-12-07 JLM VERIFIED:DD IPP REV:B AS PER REV B 11-04-05 JLM
VERIFIED BY:DD IPP Rev:C 11.12.19 PER DWG REV.C DD ver:EC

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	150 Ea	12/14/18	12/14/18	0.00	0.00	Start Up Machining-2		JSD 15/12/18
100	Hardinge	150 pcs	12/14/18	12/14/18	0.00	6.38	Hardinge		" "
120	QC	150 pcs	12/14/18	12/14/18	0.00	0.00	QC8		2/18/12/08
130	Outsource	150 pcs	12/14/18	12/14/18			MEI001-VC	9	CC 18-12-10
140	Packaging	150 pcs	12/14/18	12/14/18	0.00	0.00	Packaging2		JH DAS
150	QC	150 pcs	12/14/18	12/14/18	0.00	0.00	QC6		JAN 02 2019 63
160	HandFinish	150 pcs	12/14/18	12/14/18	0.00	0.75	HandFinish4		TF 9-89
190	Packaging	150 pcs	12/14/18	12/14/18	0.00	0.00	Packaging3-2		TF
200	QC21-SA	150 Ea	12/14/18	12/14/18	0.00	0.00	QC21		DAS 21 JAN 03 2019

Part Op 100 - 1- Machine as per Folio FB015 ***DO NOT CHAMFER OUTSIDE DIA***
 Descriptions: 130 - ***HEAT TREAT AS PER DWG D4202*** Mat'l: 6061-T6 Aluminum Tubing Per WWT-700/6
 160 - WASH SPACER AS PER QSI005
 190 - ***STOCK IN SKIDTUBE CELL***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T0.500W.058	6061-T6 Round Tube .500 X.058W	52.5000 ft (.35 ea)	90-Start up Operation	5133774 5115492

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6T0.500W.058	53	93	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.500inches $\pm$ 0.010	0.510 0.490	Product	
2	Spacer	0.058inches $\pm$ 0.010	0.068 0.048	Product	
3	Spacer	4.145inches + 0.030 - 0.010	4.175 4.135	Product	

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Container No: S135511



Part: D4202-1

Job No: 186737

Serial No/Batch: S135511

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Howkesbury, ON K64 1K7
CANADA
TEL.: 1 813 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/06/18



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO042002**

Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042002
PO Date: 12/10/18
Due Date: 12/27/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments: ASAP
Please advise with earliest lead time

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
186737		D4202-1	Spacer : Various STC's ***HEAT TREAT AS PER DWG D4202*** Mat'l: 6061-T6 Aluminum Tubing Per WWT-700/6	Firmed	-	12/27/18	150 pcs	0 pcs	150 pcs	\$2.225/pcs	\$333.75
186738				Partial	-	12/27/18	150 pcs	99 pcs	51 pcs	\$2.225/pcs	\$113.48
Sub Total:							300	99	201		\$447.23
Grand Total:											\$447.23



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PURCHASE ORDER PO042002

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
332753	1	133392

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
42002		AL-6061	2018/12/10	CLIENT

QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
300	D4202-1			10,
	(150) D4202-1	JOB 186737		
	(150) D4202-1	JOB 186738		
1 BOITE DE CARTON				

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BOITE DE CARTON	1	

CERTIFICAT

EXPÉDIÉ PAR: Shipped by:	
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QUANTITÉ EXPÉDIÉE / Quantity Shipped : 300
POIDS EXPÉDIÉ / Weight Shipped : 10,00
QUANTITÉ RESTANTE / Quantity Remaining : 0
POIDS RESTANT / Weight Remaining : 0,00

APPROUVÉ

CERTIFICAT

QUANTITÉ EXPÉDIÉE / Quantity Shipped:	300
POIDS EXPÉDIÉ / Weight Shipped :	10,00

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2018/12/17

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité

Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
332753	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
42002	N/A	AL-6061		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SOL ANNEAL

SINGLE AGING TO CONDITION T42

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
CONDUCTIVITY	38 - 44 %IACS	60	38 - 40 %IACS
HARDNESS	60 HREW MIN	60	61 - 63,5 HREW
			MESURE EN HR15TW = 63-64,3HR15TW (912)

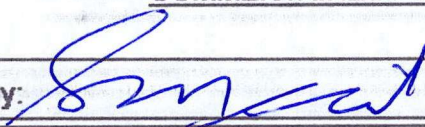
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
300	10	D4202-1 (150) D4202-1 JOB 186737 (150) D4202-1 JOB 186738 1 BOITE DE CARTON

4/1/19

COMMENTAIRES / comments

DAS
68
9-89

APPROUVÉ par / Approved by:



DATE: 2018-12-16

APPROUVÉ

METCON INC.

800 BUL. ARTHUR-SALVE, ST-EUSTACHE, QC J8R 5A8

Tél 450-431-1884

Telecopieur Fax administration 450-431-5499

Telecopieur Fax production 450-431-5494

Certificat de Conformité Certificat of Compliance

BON DE TRAVAIL	CHARGEMENT
order	load
332523	1

CLIENT: HARMESBURY

DATE: 2018-12-10

PROJ: 100-000000

PROJ: 100-000000

ON 100-000000

LIVRE À: HARMESBURY

DATE: 2018-12-10

PROJ: 100-000000

PROJ: 100-000000

ON 100-000000

COMMANDE DU CLIENT	CLASSIFICATION PIÈCE	MATÉRIEL	UNITÉS D'OEUVRE	PROGRAM
Customer po	Part description	Material	Other description	
42002	11A	AL-6061		
SPECIFICATIONS DU PROCÉDÉ				
PROCESSING SPECIFICATIONS				
SINGLE ASING TO CONDITION 11A				
SOL ANNEAL				

EXIGENCE (Requirement)	SPECIFICATIONS (Specifications)	TESTS EXÉCUTÉS (Tests performed)	RÉSULTATS DE TESTS (Test results)
CONDUCTIVITY	38 - 44 %IACS	38	38 - 40 %IACS
HARDNESS	80 HR15W	80	81 - 83.5 HR15W
MESURE EN HR15W = 88-81 3HR15W			
1012			

QUANTITÉ (Quantity)	BOITE (Box)	DESCRIPTION DES PIÈCES (Part description)
300	10	04202-1
		(100) 04202-1 JOB 100737
		(100) 04202-1 JOB 100738
		1 BOITE DE CARTON

COMMENTAIRES (Comments)

APPROUVÉ par (Approved by)	DATE: 2018-12-10
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METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
332753	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
42002	N/A	AL-6061		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications SOL ANNEAL SINGLE AGING TO CONDITION T42				
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
CONDUCT	36 - 44 %IACS	60 (60 kHz)	38 - 40 %IACS	
HARDNESS	60 HREW MIN	60	61 - 63.5 HREW MESURE EN HR15TW = 63-64,3HR15TW (912)	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
300	10	D4202-1 (150) D4202-1 JOB 186737 (150) D4202-1 JOB 186738 1 BOITE DE CARTON		

COMMENTAIRES / comments

SOL. ANNEAL 985F, 30 MIN
AGE HARDEN AMBIANT 96 HRS

DAS
68
9-89

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

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332753	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

le contenu. Toute exportation ou réexportation non autorisée est interdite.

APPROUVÉ par / Approved by:

Isabel Otero

QA Technician



DATE: 2018-12-17